

Date: Wednesday, 15/04/2009 10:11:23 AM
 User: Melanie Fauteux

Process Sheet

RUSH

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SEAT BELT REEL BRACKET ASS'Y
 Job Number : 47220
 Estimate Number : 13854
 P.O. Number :
 This Issue : 15/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : MF 09-04-15
 Comment : Est Rev: A New Issue 09.04.14 EC verified: DD

Part Number : D3925041
 Drawing Number : D3925 REVA PRELIM ASS 09.04.23
 Project Number : N/A
 Drawing Revision : A PRELIM
 Material :
 Due Date : 17/04/2009 Qty: 1 Um: Each

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1029 sf(s)/Unit Total: 0.1029 sf(s)
 6061-T6 aluminum sheet 0.125" thick
 Batch: 110062 HB 9-4-16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3925
 Dwg Rev: PRG
 Prog Rev: Lim HB 9-4-16
 2-Deburr if necessary HB 9-4-16
 *****identify as D3925-1*****

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



ENGINEERING
 APPROVAL



Comment: SECOND CHECK

5.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0450 sf(s)/Unit Total: 0.0450 sf(s)
 6061-T6 .125 Sheet
 batch: 110062 HB 9-4-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT REEL BRACKET ASS'Y

Job Number: 47220

Part Number: D3925041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3925

Dwg Rev: PRE

Prog Rev: Lim

IB 9-4-16

2-Deburr if necessary

IB 9-4-16

*****identify as D3925-3*****

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-4-16

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

09-04-16 (2)
15509.04.17

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form D3925-1 and -3 as per dwg D3925

SB 09/04/17

RTD

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-04-17 (1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. 09/04/17

(2X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

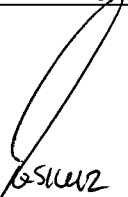

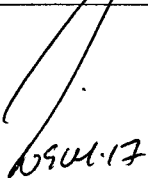
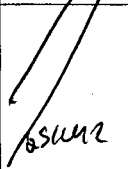
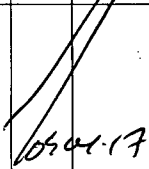
09/04/17 (1)

WORK ORDER CHANGES

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.04.17	15.5	Powder coat grey sanders (4,3,5,6) per Q51005 + Pmg 03925 M109648	[Signature]	09-04-17	1	[Signature] 09.04.17	[Signature] 09.04.17
09.04.17	15.6	QC 3 Powder COAT & Chemical Conversion Inspection	[Signature]	09.04.17 ①		[Signature] 09.04.17	[Signature] 09.04.17

PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 09/04/17
 Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 47220		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/04/17	9	1 part was found with an extra hole on it. R.C. Machine Malfunction.	 09.04.17	Scrap + destroy both parts.	 09/04/17	 09.04.17	 09.04.17	 09.04.17

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT REEL BRACKET ASS'Y

Job Number: 47220

Part Number: D3925041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD58

Rivet



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Rivet

17 2255

09/04/17

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3925

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/17

PCU

Previous page

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P.O. # 8437

09/04/17

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17

Job Completion



09/04/17

POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

DATE

09/04/17

09/04/17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

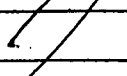
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47220
Description: SEAT BELT REEL BRACKET ASS'Y		Part Number: D3925-1
Inspection Dwg: D3925-1 Rev: PRE Lim		Page 1 of 8

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype Preliminary

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .157	+ .005 - .001	.159				
Ø .209	+ .005 - .001	.209				
1.420	+/- .010	1.421				
1.600	+/- .010	1.600				
.533	+/- .010	.530				
.38	+/- .030	.381				
.311	+/- .010	.311				
3.00	+/- .030	3.003				
3.20	+/- .030	3.201				
.400	+/- .010	.401				
1.41	+/- .030	1.414				
4.59	+/- .030	4.592				
.98	+/- .030	.982				
.288	+/- .010	.288				
5.95	+/- .030	5.948				
2.25	+/- .030	2.260				
.125	+/- .010	.121				

Measured by: KB	Audited by: 	Prototype Approval:
Date: 9-4-16	Date: 05-04-16	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	47220
Description: SEAT BELT REEL ASS'Y	Part Number:	D3925-3
Inspection Dwg: D3925-3 Rev: PRE Lim		Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

X



Preliminary

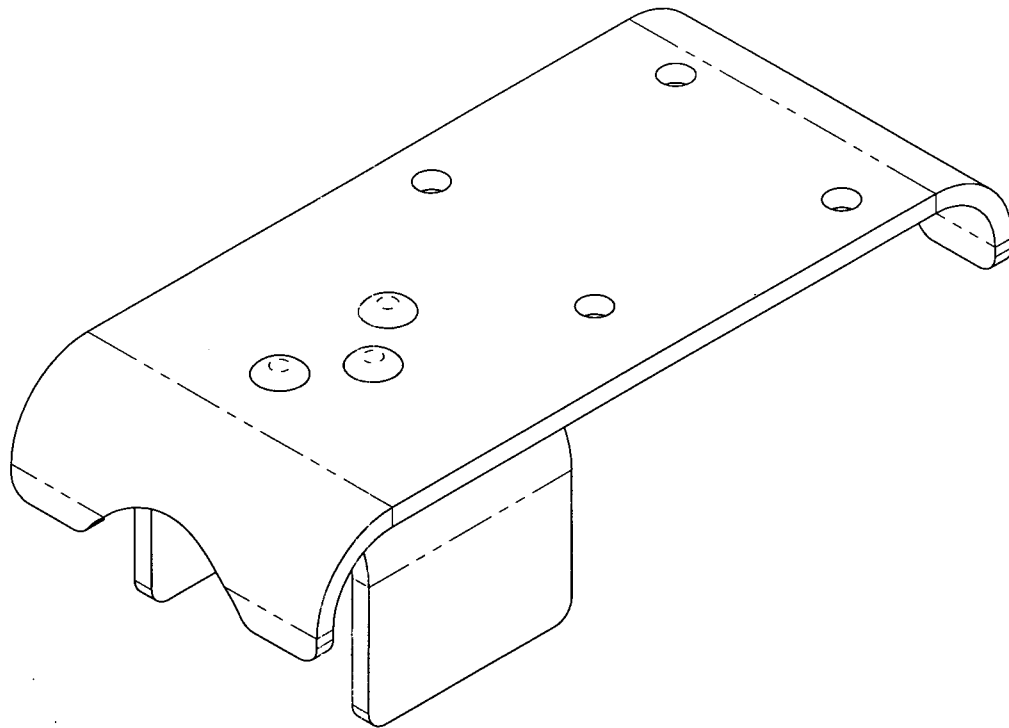
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Measured by: <u>RB</u>	Audited by: <u>[Signature]</u>	Prototype Approval: <u>[Signature]</u>
Date: <u>9-4-11</u>	Date: <u>050116</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM NO	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3925-041	SEATBELT REEL BRACKET ASSY
9	1	D3925-1	BRACKET
10	1	D3925-3	BRACKET
21	3	MS20470AD5-8	RIVET

ASS 09.04.17



D3925-041 SEATBELT REEL BRACKET ASSY

**PRELIMINARY
ISSUE**

ASS 08.04.14

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3925-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.23 lbs

A	NEW ISSUE	AJS	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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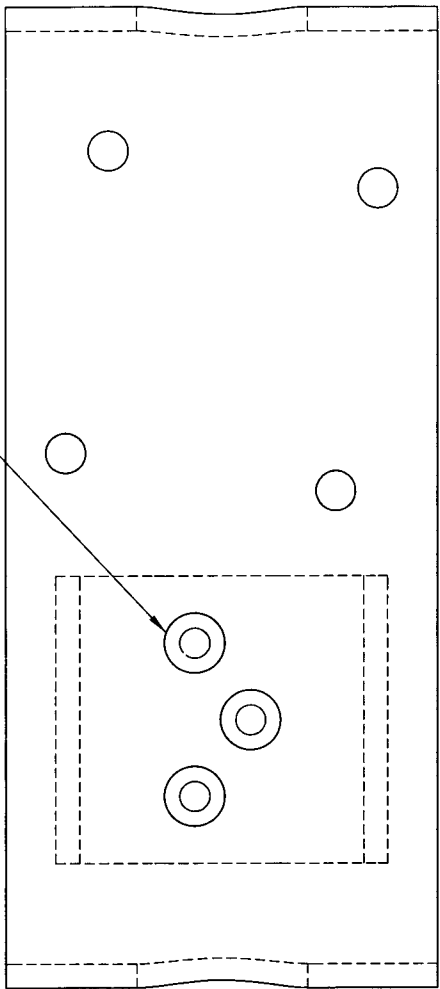
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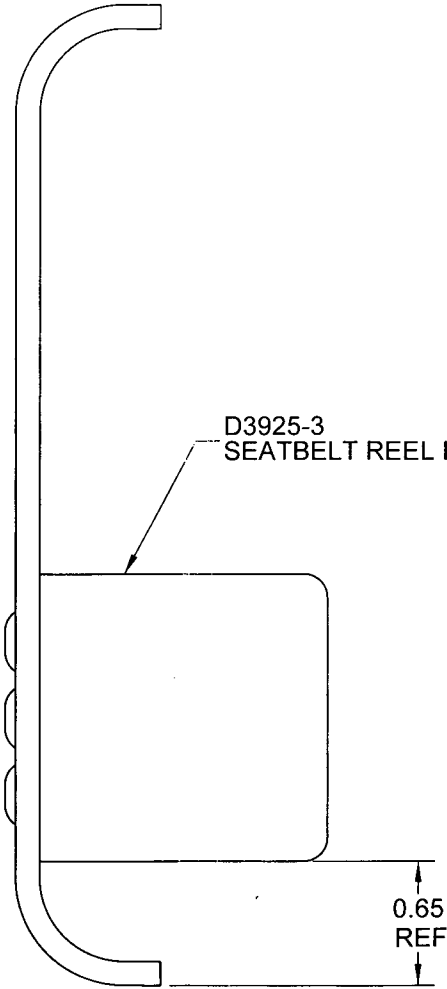
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A

MS20470AD5-8 RIVET
3 PL

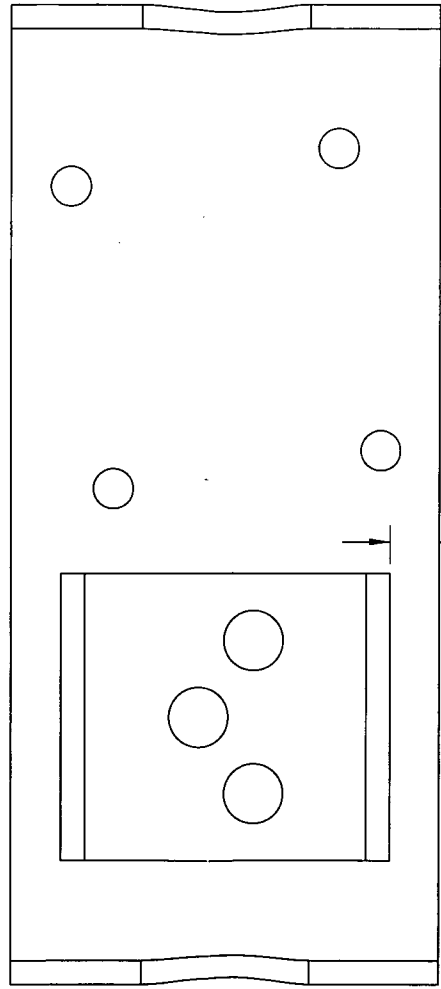


D3925-3
SEATBELT REEL BRACKET



D3925-1
SEATBELT REEL BRACKET

0.26
REF



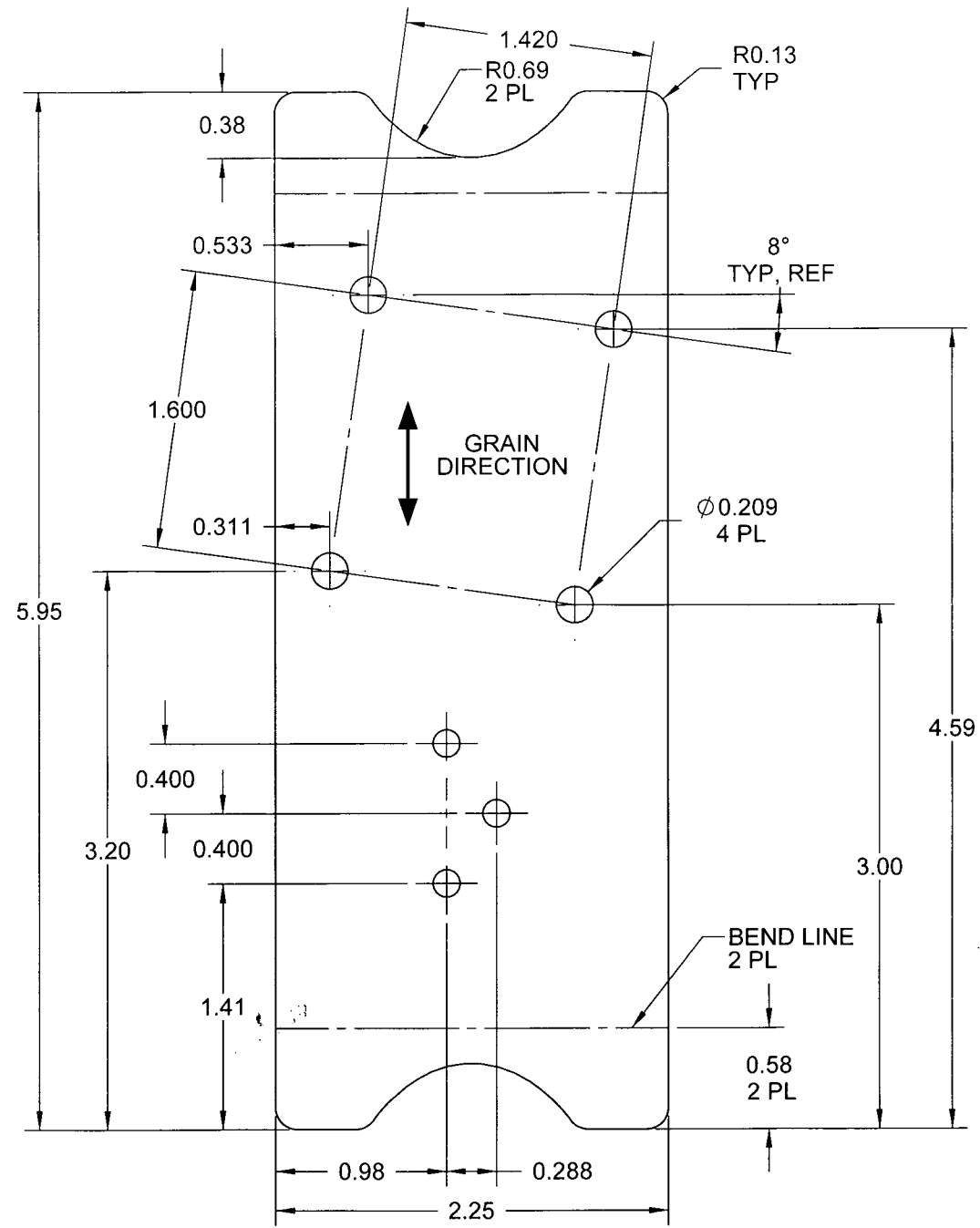
47220

D3925-041 SEATBELT REEL BRACKET ASSY

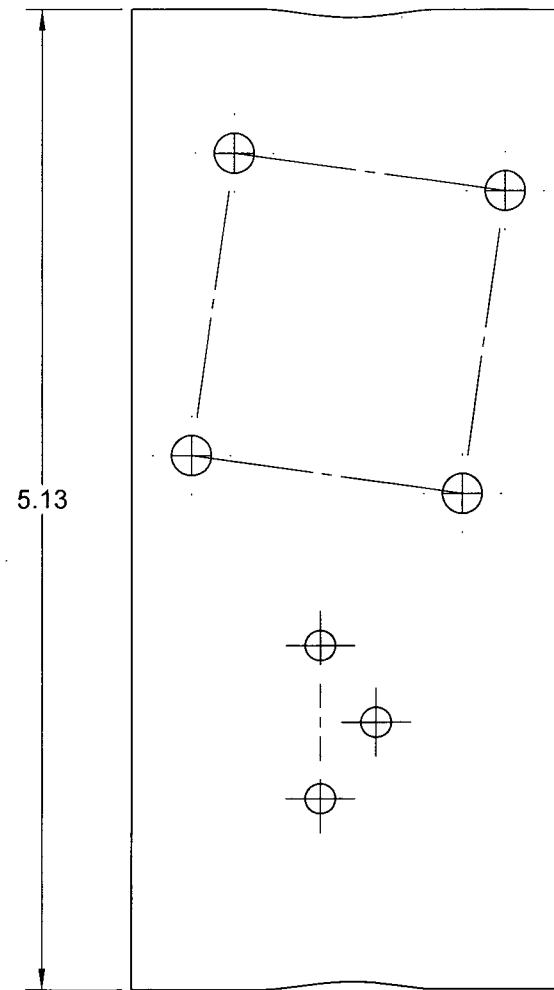
**PRELIMINARY
ISSUE**
AS OF 04.14

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3925	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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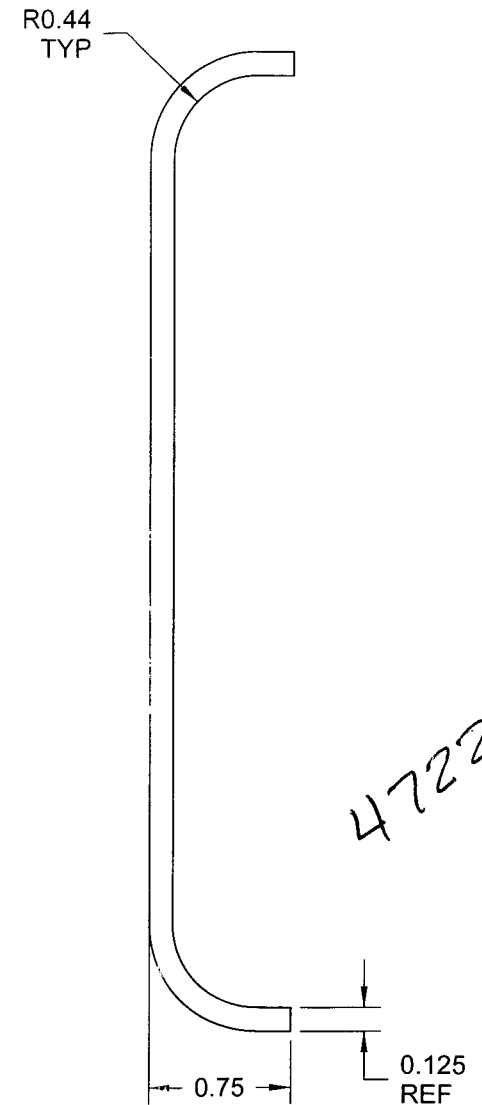
8 7 6 5 4 3 2 1



D3925-1F FLAT PATTERN



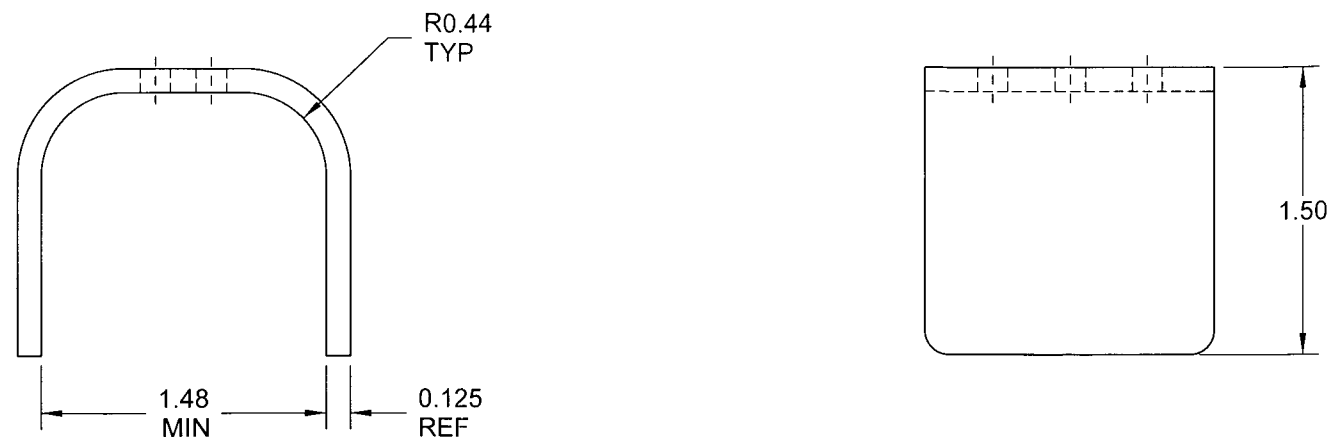
D3925-1 SEATBELT REEL BRACKET
(MAKE FROM D3925-1F)



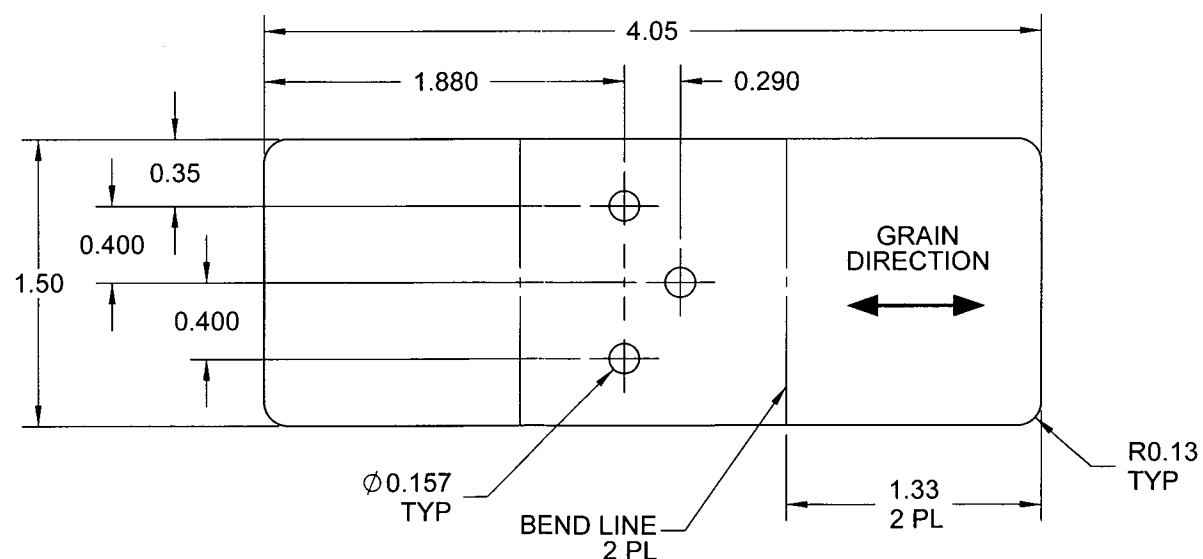
**PRELIMINARY
ISSUE**
ASS 08.04.14

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.15 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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D3925-3 SEATBELT REEL BRACKET
(MAKE FROM D3925-3F)



D3925-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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47220

**PRELIMINARY
ISSUE**

AJS 0809.14

L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: April 14, 2009 3:55 PM
To: Linda Lacelle; Alan Stocker; Eric Charbonneau
Subject: B214 parts

Linda,

Alan has given some parts for the B214 shoulder harness to Eric. I realize that time is short, but they REALLY need to get out the door this week.

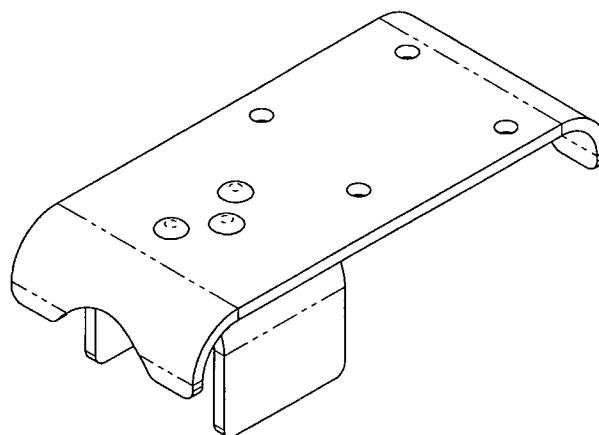
JL is already aware of the machined parts. But there are some parts for GA to make. It would be good if they could get shoe-horned into the system. (Maybe Russ could make them if necessary?)

Thanks

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

15/04/2009

ITEM NO	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3925-041	SEATBELT REEL BRACKET ASSY
9	1	D3925-1	BRACKET
10	1	D3925-3	BRACKET
21	3	MS20470AD5-8	RIVET



D3925-041 SEATBELT REEL BRACKET ASSY

47220

RELEASED
09/04/13

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3925-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.23 lbs

A		NEW ISSUE		AJS	09.03.31
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 4	
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3925		SCALE	
APPROVED		TITLE		NTS	
DE APPR.		SEATBELT REEL BRACKET ASSY			
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MS20470AD5-8 RIVET
3 PL

D3925-3
SEATBELT REEL BRACKET

D3925-1
SEATBELT REEL BRACKET

0.26
REF

0.65
REF

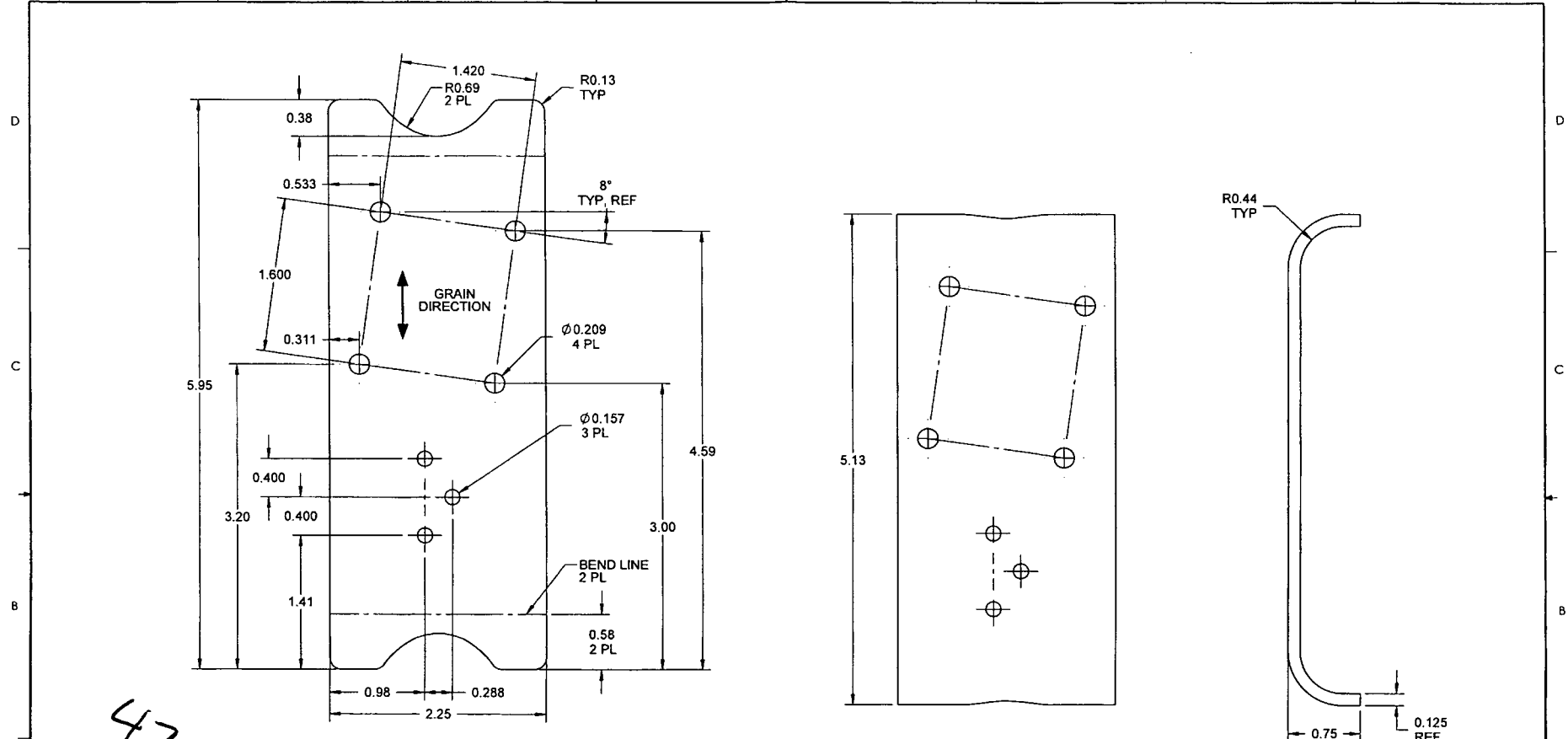
D3925-041 SEATBELT REEL BRACKET ASSY

RELEASED
09/04/03

47220

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3925	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT REEL BRACKET ASSY	NTS
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8 7 6 5 4 3 2 1



47220



D3925-1F FLAT PATTERN

D3925-1 SEATBELT REEL BRACKET
(MAKE FROM D3925-1F)

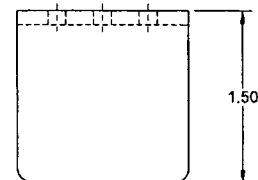
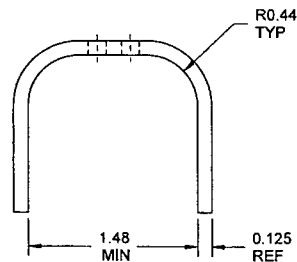
RELEASED
08/04/23

NOTES:

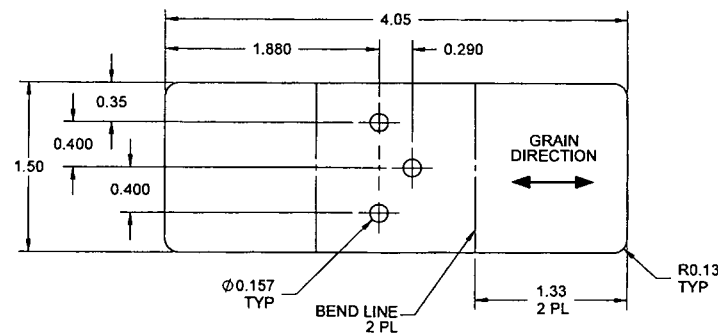
- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.15 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
DATE	09.03.31	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



D3925-3 SEATBELT REEL BRACKET
(MAKE FROM D3925-3F)



D3925-3F FLAT PATTERN

RELEASED
9/6/23 M

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3925	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT REEL BRACKET ASSY	NTS
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